Work Orde		849		*958	849*						Page 1
Item ID: Revision ID:	D3955-7			Accept	*N900	040	100)* s	etup Sta	1 7	S1*
Item Name:	Plate								Sto	^p *N	S2*
Start Date: Required Date: Reference:	1/16/13 1/31/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*	٠	Cust Item I Customer:	D:					
Approvals:		an:	Date:			ate:		R	Run Sta Sto	1 / 1	R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr	nemerous section of the section of t				/. 20/.				
D3955	Α										
100				0.00				6	0		Jm13-6-
Waterjet FLOW CNC Waterje 304 ./25		Memo 1-Cut as pe Dwg Rev:_ Prog Rev:_	er Dwg D3955	0.00							الم المحتود المراد
		2-Deburr if	necessary			*					
110		QC2- Inspect parts off r	machine FAI/FAIB	0.00							
110		Memo		0.00			٠	6	0		Jm13-6-4

Memo

Quality Control

												DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UP	DATE			·	•	
											QA C	losed:	Da	te:	
Work Ord	or.					DISPOSITION				AGAINST D	EPART	MENT,	/PROCESS		
VVOIKOIU	er.					Rework	٦ .	l	Skid-tube	Crosstube	7		Water Jet		Engineering
Part	Nο					Scrap	1		Machining	Small Fab	1	Dro	d. Eng. Coor.	_	Quality
raiti	10.			· · · -		Use-as-is	1	1	noforming	Finishing	۱,		re/Packaging	-	Other
. NCR	Nα					Work Order Update	1	1110111	Large Fab	Composite	┨ ¨``	cc/3to	Supplier		
· · · · · · · · · · · · · · · · · · ·				,			J		zarge i az		J		ouppc.	ш	<u></u>
Root					Descri	ption of work order update		Initial	Ac	tion	Sig	gn &			
Cause	٠	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	D	ate	Verificatio	n	QC Inspector
Doc/Data															
Equip/Tooling	L														
Operator	L														
Material					!				i						
Setup															
Other															
Process									*						
Supplier				-											
Training															
Unapproved															
						F	AUL	T CATE	GORY				<u> </u>		
Landi	ng (Gear				General					_				•
	L	Bending				Bend		Grain			Ovali	zed			Pressure/Forced
	L	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over,	/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part I	Incorre	ct		Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part I	Lost/Mi	ssing		Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved
Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish ·

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Work Order ID 95849 *95849* Page 2 January-21-13 8:09:33 AM Item ID: D3955-7 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Plate Start Qty: 6.00 **Start Date:** 1/16/13 **Cust Item ID:** Req'd Qty: 6.00 Required Date: 1/31/13 **Customer:** Reference: Run **Tooling:** Approvals: Process Plan: Date: Date: Stop Date: SPC (Y/N): Date: Tool ID Tool # Plan Reject Sequence ID/ **Operation** Set Up/ Accept Reject Insp. Work Center ID Qty Number Stamp Description **Run Hours** Code **Oty** 0.00 120 QC8- Inspect parts - second check *120* QC 0.00 Memo Quality Control 6x M.N. 13-06-5 Identify as per dwg & Stock Location: 570# 130 0.00 *120* Packaging 0.00 Memo Packaging QC21- Final Inspection - Work Order Release 0.00 140 *1/10*

0.00

Memo

QC

Quality Control

MB-or. a

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	OA Closed:	Data:	

										QA Closea:	Date:	
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT/		
Part N				·	Rework Scrap Use-as-is Work Order Update	T	۱ herm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
						'						· · · · · · · · · · · · · · · · · · ·
Root				Descri	ption of work order update	Init	tial	Act	ion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief	f Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material	_											
Setup	_											
Other	_				4							
Process	4											
Supplier	_											
Training				ч								
Unapproved						AULT (CATE	CODY				
Landie	ng Gear	*			General F7	AULI	CATE	JORT		 		
Lanun	Bending				Bend	Пс	rain			Ovalized	Г	Pressure/Forced
		ot Concei	ntric to (_{1/5}	BOM/Route	⊢	ardwai	re '	 	Over/Under	tolerance	Temperature/Cure
	Cracks	or concei	11110 10 1	5,° -	Broken/Damaged	\vdash		on Incomplete	 	Part Incorred	<u> </u>	Weld
	 i	/Crimped		-	Burrs	⊢	-	ions Incomplete/U	Jnclear —	Part Lost/Mi	-	Wrong Stock Pulled
	Cuffs	cimped.		-	Contamination	-		nance	-	Part Moved]
	Heat Tre	at			Countersink	\vdash	islabe			Positioned V	Vrong	
		n Strip in	Tube		Cut Too Short	\mathbf{H}	isread			Power Loss/:	_	Other
	Ripples in	•			Drill Holes	_	ffset				- L	
	` `	Vaves in E	xtrusion	,	Drawing	\vdash		alibration				, , , , , , , , , , , , , , , , , , , ,
		Sequence			Finish	По	ut of S	equence				
		vist in Tub			Folio	По	utside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

January-21-13 8:09:33 AM

Work Order ID:

95849

Parent Item:

D3955-7

Parent Item Name:

Plate

Start Date: 1/16/13

Required Date: 1/31/13

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No				sf	89.3000	4 7 2 4	2.2389474 2.5		\	Jm3-6-4
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT020		89.3							

89.3

124445

122521

124445

												DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE				
						_						QA Closed:	Date:	· · · · · · · · · · · · · · · · · · ·
Work Ord	lor.					DISPOSITION				AGAI	NST DE	PARTMENT	/PROCESS	
Work Old	IC1.					Rework	1	ľ	Skid-tube	Crosst	uhe		Water Jet	Engineering
Part	Nο					Scrap	1		Machining	Small		Pro	d. Eng. Coor.	Quality
						Use-as-is	1		noforming	Finis		1	re/Packaging	Other
NCR	No.					Work Order Update			Large Fab	Compo	~_		Supplier	
			•				_							,
Root						ption of work order update	1	Initial		tion		Sign &		
Cause	, .	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	QC Inspector
Doc/Data														
Equip/Tooling	<u> </u>													
Operator							Ì	,						
Material														
Setup														
Other		:			., ,									
Process														
Supplier	L				Contraction of the same	,							,	
Training	<u> </u>			1										
Unapproved			<u> </u>	<u> </u>										
	_						AUL	LT CATE	GORY			· · · · · · · · · · · · · · · · · · ·	-	
Landi	<u> </u>	1				General	_	1				1		1
	\vdash	Bending			_	Bend	_	Grain			_	Ovalized	<u> </u>	Pressure/Forced
	_	Centre No	ot Concer	ntric to	o/s	BOM/Route	<u></u>	Hardwa				Over/Under	├	Temperature/Cure
	—	Cracks			<u> </u>	Broken/Damaged		- 1	on Incomplete			Part Incorre	 	Weld
	—	Crushed/	Crimped.			Burrs	\vdash	-1	ions Incomplete/	Unclear		Part Lost/Mi	issing	Wrong Stock Pulled
	\vdash	Cuffs			_	Contamination	_	Mainte				Part Moved	,	
	—	Heat Trea				Countersink		Mislabe	led			Positioned V	· ·	1
	1	Inspection	n Strip in	Tube		Cut Too Short	1	Misread	l		· 1	Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	95849
Description: Plate	Part Number:	D3955-7
Inspection Dwg: D3955 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prot	otype
---	---------------	------	-------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.201	+0.005/-0.001	0.201"	_		V	JLmoi
1.31	+/-0.030	1.310"	<u> </u>		V	
10.75	+/-0.030	10.751	_		V	Produtos
6.886	+/-0.010	6.890"	-		ν	
4.75	+/-0.030	4.762"	_		V	
0.120	+/-0.010	0.117"	_	-	ν	
						•
						7
,						
<u> </u>						
			·			
			8			
			0Ar			

Measured by:	Jm	Audited by:	200	, ** - * b	Prototype Approval:	N/A
Date:	13-6-4	Date:	13.6	9	Date:	N/A

Rev	Date	Change	Revised	by	Approved
Α	09.07.29	New Issue	KJ	1Δ	14
В	09.11.04	Dimension 0.120 was 0.125	KJ >	Kt-	
				77T	

95849 Ø0.201 2 PL R1.00 -€ SYM 4.75 29° 1.31 - 10.75

D3955-X PLATE

General Table								
P/N T (in) T (GA) WEIGHT (lbs)								
D3955-5	0.060	16	0.64					
D3955-7	0.120	11	1.28					

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304S'T'GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: SEE TABLE

DESIGN	DS,	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	150	D3955	SHEET 3 OF 5
APPROVED	M	TITLE	SCALE
DE APPR.	-14	SKIDTUBE TUNING KIT	NTS
DATE 09.07.21		THIS DOCUMENT IS PRINTED AND SOURCE BY DART A ERROSPACE LITD THIS DOCUMENT IS PRINTED HIS CONSTITUTION AND IS SUPPLIED ON THE DIFFESS CONSTITUTION THAT IT IS NOT TO JET USED FOR ANY PRINTED OF CONTROL PRINTED TO ANY OTHER PRINTED WITHOUT	